



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

4.5NR-10

Job Sheet 196337



REPRINT

Part No: 4.5NR-10

Job Qty: 30 pcs

Part Name: Lock Roller Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/11/19

Job Tracking No:

Due Date: 7/29/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: 4.5NR-10 rev.5 IPP REV:A 18.06.22 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	SL-154 - 1	30 pcs		7/29/19	1.00	3.00	SL-154 - 1		
130	QC 2	30 pcs		7/29/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		



Container No: S193819



Part: 4.5NR-10

Job No: 196337

Serial No/Batch: S193819

Revision: 5

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/15/19

				QC 2 - 71	Plex 7/29/19 12:44 PM Dart.Renwick.Jennifer
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140	QC 8	30 pcs	7/29/19	0.00 0.00	
150	Outsource - 1 - Heat Treat	30 pcs	7/29/19		MEI001-VC 10
160	Packaging 2-1 - Receive - B4B	30 pcs	7/29/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
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					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B

See Attached

				Packaging 2 - 31 - B4B	7/29/19 12:44 PM Dart.Renwick.Jennifer
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170	QC 6	30 pcs	7/29/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
180	Outsource - 15 - Nickel Plate	30 pcs	7/29/19		GRO002-VC 8
190	Packaging 2-2 - Receive - B4B	30 pcs	7/29/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
195	QC 6	30 pcs	7/29/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
196	Rework - 1 - Startup	30 pcs	7/29/19		GRO002-VC
197	Rework	30 pcs	7/29/19	0.00 0.00	Packaging 2 - 1 - B4B
198	Rework	30 pcs	7/29/19	0.00 0.00	QC 6 - 40
200	Packaging 3-1 - Stock - B4B	30 pcs	7/29/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B

See Attached

DAS
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9-89

AUG 07 2019

DAS
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AUG 15 2019
AUG 15 2019

Part Op **120** - MORI SL-154 LATHE - 1-Machine as per folio FC219 FOLIO REV: _____ DWG REV: _____ 2-
 Descriptions: Debur
130 - QC2- Inspect parts off machine FAI/FAIB
140 - QC8- Inspect parts - second check
150 - HEAT TREAT TO RC 50-55 1-Issue P/O; P/O _____ RC _____ 2- Bead blast 3- Material type ;
 01 4- Certificate of Conformity is required
160 - Receive & Inspect for Damage & Mat'l Certs
170 - QC6- All purchased or subcontracted products
180 - Outside Processing - Nickel Plate -Issue P/O: P/O 44220 -Nickel plate, QQ-N-290, Class 2, Grade E or F -
 Nickel Plate .0004- .0006 Bake after plating - Certificate of Conformity is required
190 - (Receive & Inspect for Damage & Mat'l Certs)
195 - QC6- All purchased or subcontracted products
196 - -Issue P/O; _____ -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E -Nickel
 Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required
197 - PAC 2
198 - QC 6
200 - Identify as per dwg & Stock Location: _____
210 - QC21- Final Inspection - Work Order Release

Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R0.500	Tool Steel Round Bar 0.500 dia.	3.0900 ft (.103 ea)	120-SL-154 - 1	

Operation	Component Part	Required	Inventory	Allocated
120-SL-154 - 1	MT-O1-R0.500	3	17	0

Part Specifications
Specifications could not be found.



Dart Aerospace Ltd.
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4.5NR-10
Job Sheet 196337



Part No: 4.5NR-10

Job Qty: ~~40 pcs~~

Part Name: Lock Roller Pin



30 pcs.

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/11/19

Job Tracking No:

Due Date: 7/29/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: 4.5NR-10 rev.5 IPP REV:A 18.06.22 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
120	SL-154 - 1	10 pcs	7/29/19	7/29/19	1.00	1.00	SL-154 - 1	<i>JB 19-06-26</i>
130	QC 2	10 pcs	7/29/19	7/29/19	0.00	0.00	QC 2 - 1	
							QC 2 - 2	
							QC 2 - 3	
							QC 2 - 4	
							QC 2 - 5	
							QC 2 - 6	
							QC 2 - 7	
							QC 2 - 8	
							QC 2 - 9	
							QC 2 - 10	
							QC 2 - 11	
							QC 2 - 12	
							QC 2 - 13	
							QC 2 - 14	
							QC 2 - 15	
							QC 2 - 16	
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							QC 2 - 88	
							QC 2 - 89	
							QC 2 - 90	
							QC 2 - 91	
							QC 2 - 92	
							QC 2 - 93	
							QC 2 - 94	
							QC 2 - 95	
							QC 2 - 96	
							QC 2 - 97	
							QC 2 - 98	
							QC 2 - 99	
							QC 2 - 100	
140	QC 8	10 pcs	7/29/19	7/29/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	

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Container No: S193819



Part: 4.5NR-10

Job No: 196337

Serial No/Batch: S193819

Revision: 5

Inspector:

Exp Date:

One more to add to Nickel re-works

JB 19-06-26

				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	148 18/6/26
				QC 8 - 57	
150	Outsource - 1 - Heat Treat	10 pcs	7/29/19	MEI001-VC	10 148 2019-06-27
160	Packaging 2-1 - Receive - B4B	10 pcs	7/29/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
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					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
170	QC 6	10 pcs	7/29/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
180	Outsource - 15 - Nickel Plate	10 pcs	7/29/19		GR0002-VC LUT002 148 2019-07-10
190	Packaging 2-2 - Receive - B4B	10 pcs	7/29/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B

Plex 6/11/19 2:57 PM Dart.Renwick.Jennife

				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
195	QC 6	10 pcs	7/29/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
200	Packaging 3-1 - Stock - B4B	10 pcs	7/29/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
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					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
210	QC 21 - SA	10 pcs	7/29/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 120 - MORI SL-154 LATHE - 1-Machine as per folio FC219 FOLIO REV: <u>AA</u> DWG REV: <u>5.</u> 2-					

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Descriptions: Deburr

130 - QC2- Inspect parts off machine FAI/FAIB

140 - QC8- Inspect parts - second check

150 - HEAT TREAT TO RC 50-55 1-Issue P/O; P/O _____ RC _____ 2- Bead blast 3- Material type ;

01 4- Certificate of Conformity is required

160 - Receive & Inspect for Damage & Mat'l Certs

170 - QC6- All purchased or subcontracted products

180 - Outside Processing - Nickel Plate -Issue P/O: P/O 43954 -Nickel plate, QQ-N-290, Class 2, Grade E or F - Nickel Plate .0004- .0006 Bake after plating - Certificate of Conformity is required

200 - Identify as per dwg & Stock Location: _____

210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R0.500	Tool Steel Round Bar 0.500 dia.	2 ft (.2 ea)	120-SL-154 - 1	<u>5091508</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-SL-154 - 1	MT-O1-R0.500	2	21	0

Part Specifications

Specifications could not be found.

Plex 6/11/19 2:57 PM Dart.Renwick.Jennifer



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043864



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043864

PO Date: 6/27/19

Due Date: 7/19/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

E-MAILED
2019-07-03

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194916	646.3314	Blade : Various STC's HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL	Firmed	-	7/19/19	29 pcs	0 pcs	29 pcs	\$11.1724/pcs	\$324.00
2	196337	4.5NR-10	Lock Roller Pin HEAT TREAT TO RC 50-55 1-Issue P/O; P/O _____ RC _____ 2- Bead blast 3- Material type ; 01 4- Certificate of Conformity is required	Firmed	-	7/19/19	30 pcs	0 pcs	30 pcs	\$10.3333/pcs	\$310.00
3	196068	D5557-1	Cutter Blade : Various STC's PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed	-	7/19/19	20 pcs	0 pcs	20 pcs	\$16.20/pcs	\$324.00
Grand Total:											\$958.00

30 x JUL 09 2019

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Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB043864



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/3/19 10:14 AM Dart.Guerin.Kimberley

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
337654	1	138510

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

LIVRÉ À /Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
HB043864 ✓		O1	2019/6/28	client

QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
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✓ 30 4.5NR-10
(30) 4.5NR-10
JOB 196337

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1,

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 30

POIDS EXPÉDIÉ / Weight Shipped : 1,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

RECEIVED

JUL 09 2019

DART AEROSPACE LTD.

APPROUVÉ

CERTIFICAT

QUANTITÉ EXPÉDIÉE Quantity Shipped: 30

POIDS EXPÉDIÉ / Weight Shipped : 1,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2019/07/07

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337654	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB043864 ✓	N/A	O1		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

SEL HARDEN

HARDEN AND TEMPER

DAS
61
9-89

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	50 - 55 HRC	30 (907)	51 - 53 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
30 ✓	1	4.5NR-10 ✓ (30) 4.5NR-10 JOB 196337 1 BOITE DE CARTON

10/7/19

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

[Signature]



DATE: 2019-07-06

APPROUVÉ
[Signature]

WETCOR INC.

500 ВОЛН. КРИНГ-СОВА, 21-ЕНДЛАШЕ. ОС. 17К 5242

4881-ET4-024:19T

8842-124-024: molalite in the xbf \ the 1000010T

ACROSS THE OCEAN MOUNTAIN RANGE / WASHINGTON STATE

01 bapqde lA 3rVL
30492093A TRAC
W33093BA DTCT
YPU823ANVAH
TNI AGN WO

215 1000000 \ TMELO
EJACBQ9BA7TAQ
1100095BA0T51
YPO82BNWAH
TN1 ABN MO

PROCEDURE SPECIFICATIONS

NEW YORK LEGAL

РЕЗУЛЬТАТЫ РАБОТЫ

ethlen \ STSAT 30 STATJUS39	bermotiq \ 25TUC3X3 STSATbaibag9 \ 21MOTADJIC392	memerijupen \ 20VIBOX3
CRM 23 - 13	03	CRM 25 - 03
		22210394H

(708)

QUANTITE	BOITE	DESCRIPTION DES PIECES
30	1	BOITE 48933V 01-1918-10 (30) 1 2116-10 BOITE DE CARTON

23.11.1990

20-YO-Eros : 3TAQ

Yd bsvorqqa \ wq žvuo77qqa



METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337654	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB043864 ✓	N/A	O1		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN			DAS 61 9-8g	
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	50 - 55 HRC	30 (907)	51 - 53 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
✓ 30	1	4.5NR-10 ✓ (30) 4.5NR-10 JOB 196337 1 BOITE DE CARTON		

DAS
61
9-89

COMMENTAIRES / comments

SALT HARDEN 1475°F - 40 MINS

TEMPER 600°F - 2:00 HRS

RETEMPER 675°F - 2:00 HRS

GLASS BEAD

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée.

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337654	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

APPROUVÉ par / Approved by:

DATE: 2019-07-08

Lucie Desmarais
QA Technician





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043954



Supplier: ULT002-VC
Ultraspec Inc.
2600 De Miniac
St Laurent
QC
H4S L7S Canada
Phone: 5143371782
Fax: 5143371784

PO No: POHB043954
PO Date: 7/9/19
Due Date: 7/22/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms: Prepaid
Special Comments:

E-MAILED
2019-07-15

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193448	C45-4-4A	C45 Load Beam Assembly Outsource15 (Outside Processing - Nickel Plate) -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate .0009-.0011 - Certificate of Conformity is required	Firmed	-	7/22/19	7 pcs	0 pcs	7 pcs	\$10.48/pcs	\$73.36
							7x				
							JUL 23 2019				
							5195984				
2	193895	C3-12-3	Lock - C3 Hook (Outside Processing - Nickel Plate) -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Certificate of Conformity is required	Firmed	-	7/22/19	20 pcs	0 pcs	20 pcs	\$5.25/pcs	\$105.00
							20x				
							JUL 23 2019				
							5190711				
3	197132	C10-9-4	Latch Shaft Bearing (Outside Processing - Nickel Plate) -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required	Firmed	-	7/22/19	27 pcs	0 pcs	27 pcs	\$5.80/pcs	\$156.60
							27x				
							JUL 23 2019				
							5194938				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043954



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	196337	4.5NR-10	Lock Roller Pin Outside Processing - Nickel Plate -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 Bake after plating - Certificate of Conformity is required	Firmed	-	7/22/19	30 pcs	0 pcs	30 pcs	\$5.80/pcs	\$174.00
							30 x JUL 23 2019				
											5193819.
5	193897	C3-13-4	KEEPER Outside Processing - Nickel Plate -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Certificate of Conformity is required	Firmed	-	7/22/19	20 pcs	0 pcs	20 pcs	\$5.25/pcs	\$105.00
							20 x JUL 23 2019				
											5192911
6	193861	C10-4	Lock (Outside Processing - Nickel Plate) -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Certificate of Conformity is required	Firmed	-	7/22/19	12 pcs	0 pcs	12 pcs	\$6.75/pcs	\$81.00
							12 x JUL 23 2019				
											5191999
Grand Total:										\$694.96	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/15/19 4:14 PM Dart.Guerin.Kimberley

**ULTRASPEC INC.**

Anodizing, Plating, Painting

2600 De Miniac, St-Laurent, QUEBEC, H4S1L7

Tel.: 514-337-1782

Fax.: 514-337-1784



0 4 7 0 7 0 - 1



Form No. 104, Rev. 10

CERTIFICAT DE CONFORMITÉ / CERTIFICATE OF COMPLIANCE**BON DE LIVRAISON / PACKING SLIP****047070-1**

BUYER:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN ST.

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Livrer À / Ship To:

DART AEROSPACE LTD

1270 ABERDEEN ST.

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Date	Généré Par Generated By	Packaging Paquets	Vendor Code Code Vendeur	Transport	Customer PO / BC Client
22-Jul-2019	Fadi Suleman				POHB043954 ✓

#	No. de Série / Part Number Line Item Details	Description/Information Additionnelle Additional Information	Commandée Ordered	Acceptée Accepted	Rejetée Rejected
1	C10-9-4 Rev. ✓ MAT -- Prog./Prime./COMM	LATCH SHAFT BEARING Job No./WO. 197132 GLASS BEAD BLAST WITH NO. 7 GRADE PER MIL-STD-1504, REV. C ELECTROLESS NICKEL PLATING PER ASTM-B-733, REV. 15, TYPE IV, CLASS 3, SC2, WITH HYDROGEN EMBRITTEMENT RELIEF	27	27 ✓	0
2	4-5NR-10 Rev. ✓ MAT -- Prog./Prime./COMM	LOCK ROLLER PIN Job No./WO. 196337 GLASS BEAD BLAST WITH NO. 7 GRADE PER MIL-STD-1504, REV. C ELECTROLESS NICKEL PLATING PER ASTM-B-733, REV. 15, TYPE IV, CLASS 3, SC2, WITH HYDROGEN EMBRITTEMENT RELIEF	30	30 ✓	0

RECEIVED**JUL 22 2019****DART AEROSPACE LTD.**

CERTIFICATE OF COMPLIANCE : I certify that the parts included on this certificate have been processed as per specifications listed above and conform to all the requirements detailed in the contract or purchase order, this compliance is supported by a thorough inspection of parts and regular qualification of material processing facilities

Ultraspec Inc.

Authorized Signature : _____

Fadi Suleman

Parts

Received by : _____

All claims with reference to this order must be made within 30 days from receipt of good.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044220



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044220

PO Date: 8/7/19

Due Date: 8/14/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:**Special Comments:**

E-MAILED
2019-08-08

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198524	PC250-300A	Load Beam Assembly (Outside Processing - Nickel Plate) -Issue P/O; -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed	-	8/14/19	2 pcs	0 pcs	2 pcs	\$58.2169/pcs	\$116.43
2	197132	C10-9-4	Latch Shaft Bearing -Issue P/O; -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E --Nickel Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/14/19	27 pcs	0 pcs	27 pcs	\$3.0669/pcs	\$82.81

Plex 8/8/19 3:29 PM Dart.Guerin.Kimberley



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044220



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	193448	C45-4-4A	C45 Load Beam Assembly -Issue P/O; _____ -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E --Nickel Plate .0004-.0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/14/19	7 pcs	0 pcs	7 pcs	\$25.5169/pcs	\$178.62
							7X	AUG 15 2019			
											5193448.
4	193895	C3-12-3	Lock - C3 Hook -Issue P/O; _____ -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E -Nickel Plate .0004-.0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/14/19	20 pcs	0 pcs	20 pcs	\$3.4669/pcs	\$69.34
							20X	AUG 15 2019			
											5190711
5	193897	C3-13-4	KEEPER -Issue P/O; _____ -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E -Nickel Plate .0004-.0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/14/19	20 pcs	0 pcs	20 pcs	\$2.3669/pcs	\$47.34
							20X	AUG 15 2019			
											5192911
6	196337	4.5NR-10	Lock Roller Pin -Issue P/O; _____ -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E -Nickel Plate .0004-.0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/14/19	30 pcs	0 pcs	30 pcs	\$2.0669/pcs	\$62.01
							30X	AUG 15 2019			
											5193819.
7	193861	C10-4	Lock -Issue P/O; _____ -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E --Nickel Plate .0004-.0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/14/19	12 pcs	0 pcs	12 pcs	\$4.5169/pcs	\$54.20
							12X	AUG 15 2019			
											5191999
Grand Total:										\$610.74	

Grand Total: \$610.74



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044220



Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/8/19 3:29 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021397-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupepaltech.com

Bon de Livraison / Packing Slip

021397 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
14-Aug-2019		Jigar Patel		POHB044220 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	PC250-300A ✓ Rev.	PC250-300A E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0009 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL-200 CH	2	2 ✓	0	0	0
2	C10-9-4 ✓ Rev.	C10-9-4 E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0004 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL STEEL CH	27	27 ✓	0	0	0
3	C45-4-4A ✓ Rev.	C45-4-4A E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0009 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL ALUM CH	7	7 ✓	0	0	0
4	C3-12-3 ✓ Rev.	C3-12-3 E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0005 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL STEEL CH	20	20 ✓	0	0	0
5	C3-13-4 ✓ Rev.	C3-13-4 E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0004 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL STEEL CH	20	20 ✓	0	0	0
6	4.5NR-10 ✓ Rev.	4.5NR-10 E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0004 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL STEEL CH	30	30 ✓	0	0	0

RECEIVED

AUG 15 2019

DART AEROSPACE LTD.



Certificat de Conformité / Certificate of Compliance

(021397-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

021397 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax:.

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
14-Aug-2019		Jigar Patel		POHB044220				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
7	C10-4 Rev.	C10-4 E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0004" OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL STEEL CH	12	12	0	0	0
8	BAKING CHARGE Rev.	BAKING CHARGE 01 -BAKING, HYDROGEN EMBRITTLEMENT RELIEF	BAKE MIN-CHG	1	1	0	0	0

DAS
81
9-89

Notes Additionnelles / Additional Notes

2 mid-size
Boxes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Jg JAY

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.